

Work Order ID 77589

77589

Page 1

Tuesday, December 13, 2011 2:44:31 PM

Item ID: D3017-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Back Frame Assembly
 Start Date: 12/13/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/5/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 1/12/13 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3017	Rev B

100 Weld per dwg A/R 4130 rod Batch: M118875 0.00
 Large Fab
100
 Large Fab
 Large Fab
 Memo 0.00
 1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017
 2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)
 3-Drill holes in D3017-5 Using DT8622
 4-Deburr
 5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598
 6-Drill holes in back frame using DT8621

12-2-29 (X1)

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00
 Quality Control

1 0 BE 12/02/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 7:50 OVEN TEMPERATURE: 320 °F FINISH TIME: 8:20	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

Handwritten: 12/03/02

Handwritten: 1 BL 12-3-2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>G-A</u>	0.00							
150									
Packaging	Memo <u>B 76558</u>	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/13/11 [Signature]

012-03-4
①

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, December 13, 2011 2:44:35 PM

Page 1

Work Order ID: 77589

77589

Parent Item: D3017-041

D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083		Purchased	No			100	f	45.6570	2.458	2.587368			
M4130NT0 750W 083									**			<u>EL 12-2-27</u>	
4130 RD Tube .750 x.083W													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			MAT033		45.657								
			117579		21.74				<u>2.58</u>				
			117973		23.917								
M4130NT0.750W.049		Purchased	No			100	f	51.2700	11.125	11.71053			
M4130NT0 750W 049									**			<u>EL 12-2-27</u>	
4130 RD Tube .750 x.049W													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			MAT033		51.27								
			118772		51.27				<u>9.1</u>				
D3017-11		Manufactured	No			100	Each	60.0000	2	2			
D3017-11									**			<u>EL 12-2-27</u>	
cap													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA021		60								
			76851		60				<u>2</u>				
D3017-7		Manufactured	No			100	Each	16.0000	3	3			
D3017-7									**			<u>EL 12-2-27</u>	
Lug													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			WA021		16								
			69166		1								
			70871		7				<u>3</u>				
			70905		8								

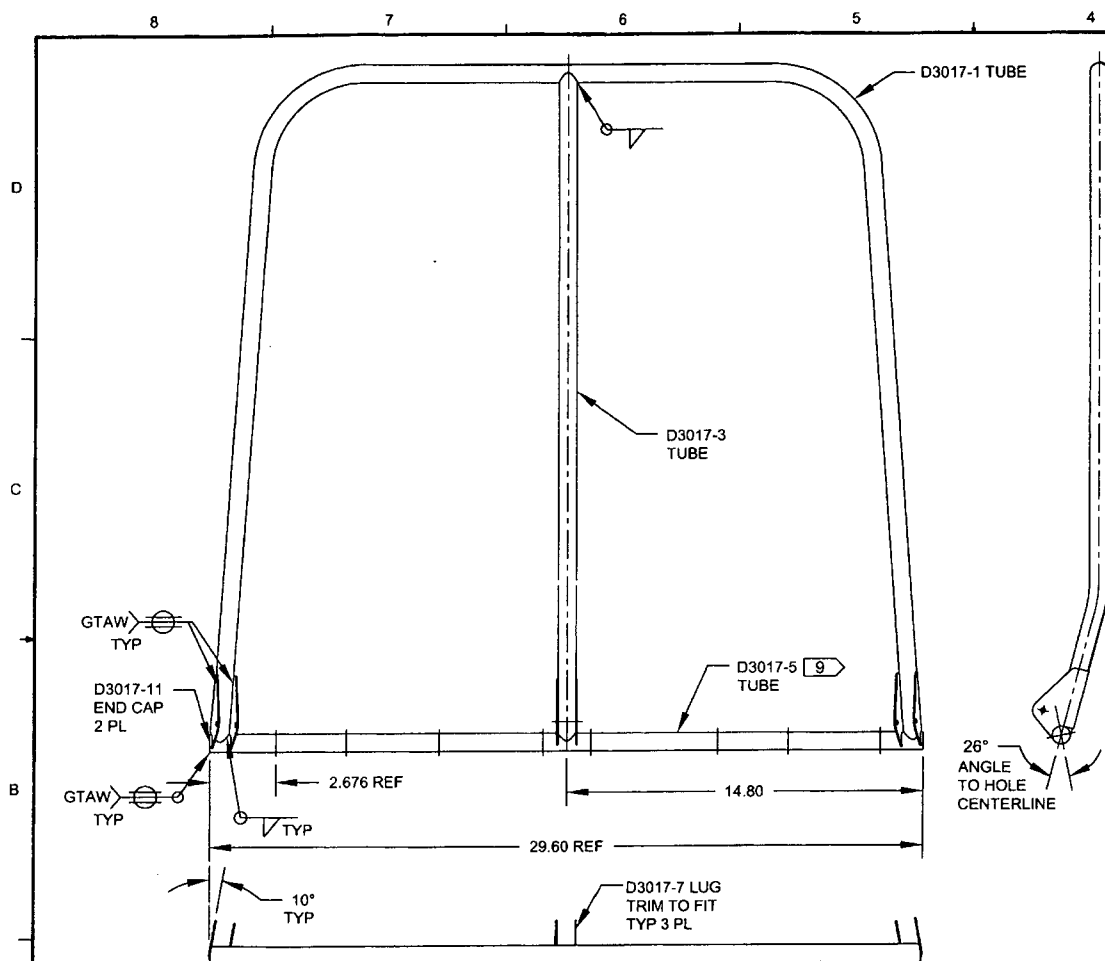
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NOTE: Date & initial all entries



ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK COPY
NO. 71589

11-12-B

RELEASED
2010-02-02
WJP

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004

9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, -5 TUBE WALL THKNS REV'D (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

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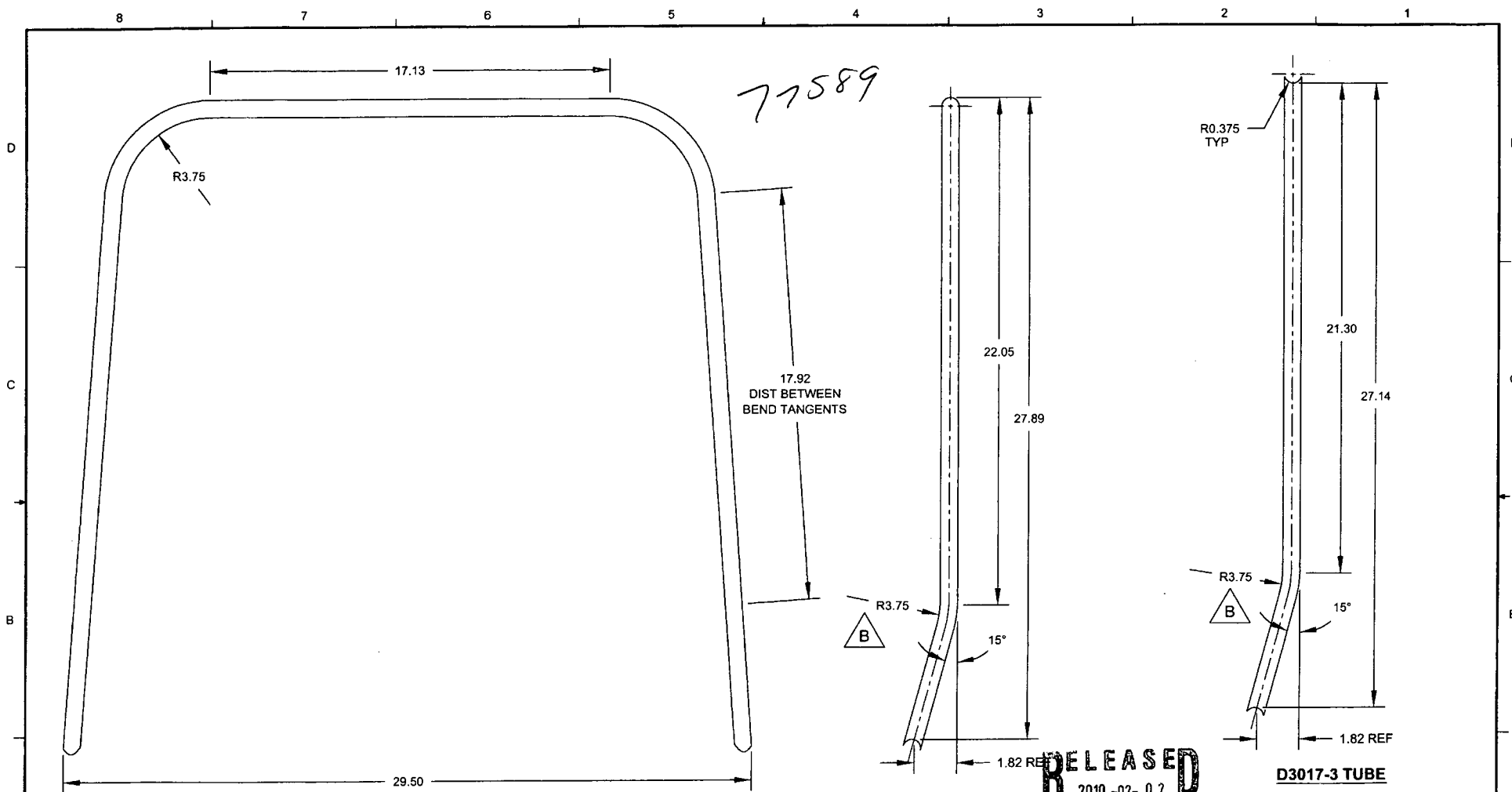
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3017-1: 2.38 lbs; D3017-3: 0.84 lbs.

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MFG. APPR.		D3017	SHEET 2 OF 4
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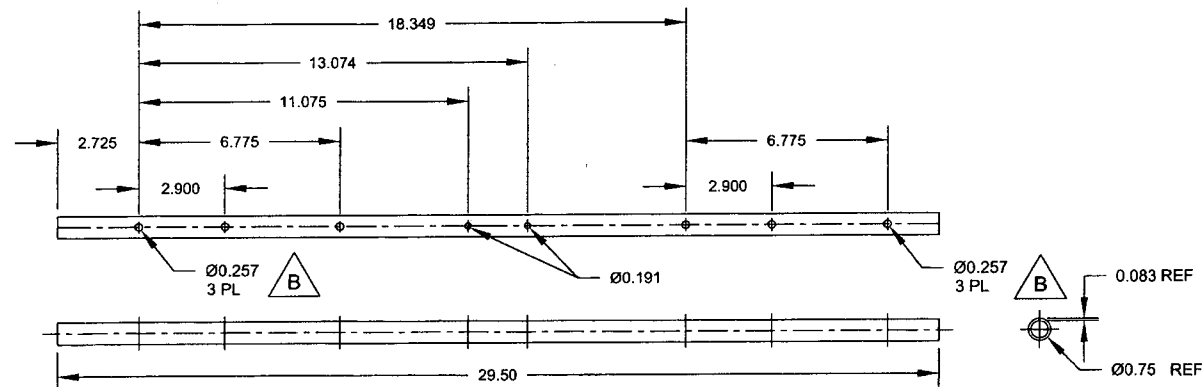
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NOTE: Date & initial all entries



D3017-5 TUBE

RELEASED
2010-02-02
[Signature]

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.89 lbs



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MFG. APPR.	<i>[Signature]</i>	D3017	SHEET 3 OF 4
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Dart Aerospace Ltd

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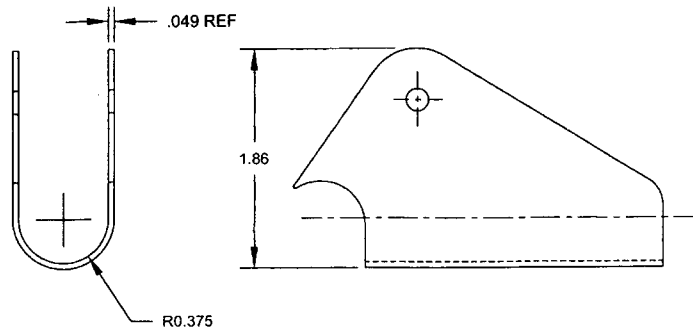
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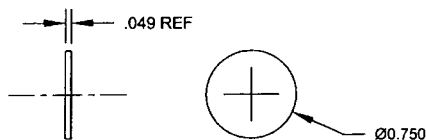
C

B

A

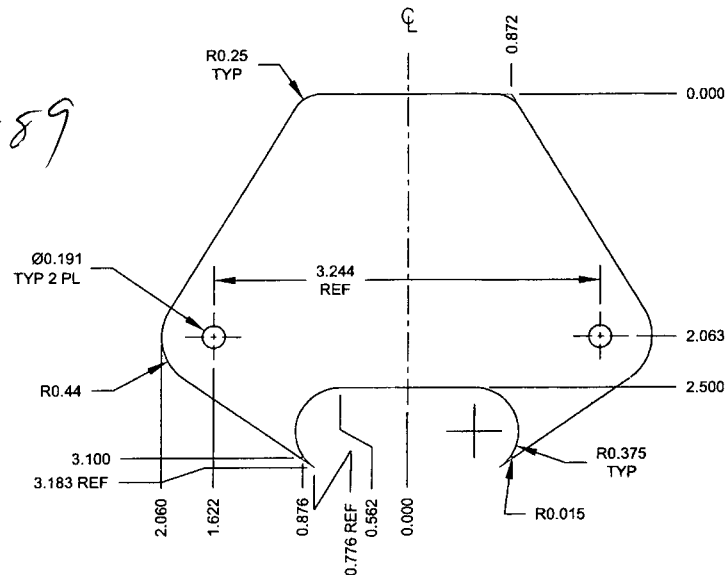


D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP

17589



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
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8 7 6 5 4 3 2 1

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